

Work Order ID 65670

January 21, 2011 1:48:43 PM



Page 1

Item ID: D4275-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Beam

Start Date: 1/21/11 Start Qty: 2.00



Cust Item ID:

Required Date: 2/01/11 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: W

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4275

A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blank to 39.750"
Batch: 114352

B.A

11/01/28

2

φ

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FB006
DWG REV: A
FOLIO REV: AA

B.A

11/01/28

2

φ

2- deburr rough edges

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

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Page 2

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Stop



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Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

B.A 11/01/28

2

0



QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

CR 11/02/01

2

0



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2 BL 11-02-2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 65670

January 21, 2011 1:48:44 PM



Page 3

Item ID: D4275-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Beam

Start Date: 1/21/11 Start Qty: 2.00



Cust Item ID:

Required Date: 2/01/11 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

145

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M 11595L

START. 7:30
OVEN.T. 0.00 320°
FINISH. 8:00

2

PR 11-02-3

Powder Coating

Memo

MASK AS PER DWG

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> 11/02/02 X 2 0

180

Identify as per dwg & Stock Location: *196*

0.00



Packaging

Memo

0.00

Packaging

1/4/3 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 65670

January 21, 2011 1:48:44 PM



Page 4

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Stop



Item Name: Fwd Beam

Start Date: 1/21/11 Start Qty: 2.00



Cust Item ID:

Required Date: 2/01/11 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/04

VMP
11-02-04

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

January 21, 2011 1:48:43 PM

Page 1

Work Order ID: 65670

Parent Item: D4275-1

Parent Item Name: Fwd Beam



Start Date: 1/21/11

Required Date: 2/01/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-11-17 JLM VERIFIED BY:DD IPP
rev:B 10.12.02 AS PER DWG REV.A DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M6061T6B1.000X04.00 0 | | Purchased | | No | | 100 | f | 53.2995 | 3.3125 | 6.973684 | | | |



6061-T6 Bar 1.00 x 4.00



Location

Loc Qty

Loc Code

MAT03

53.2995

107221

45.2937

✓ 114352

8.0058

6.9736^{ft}

LA 11/01/28

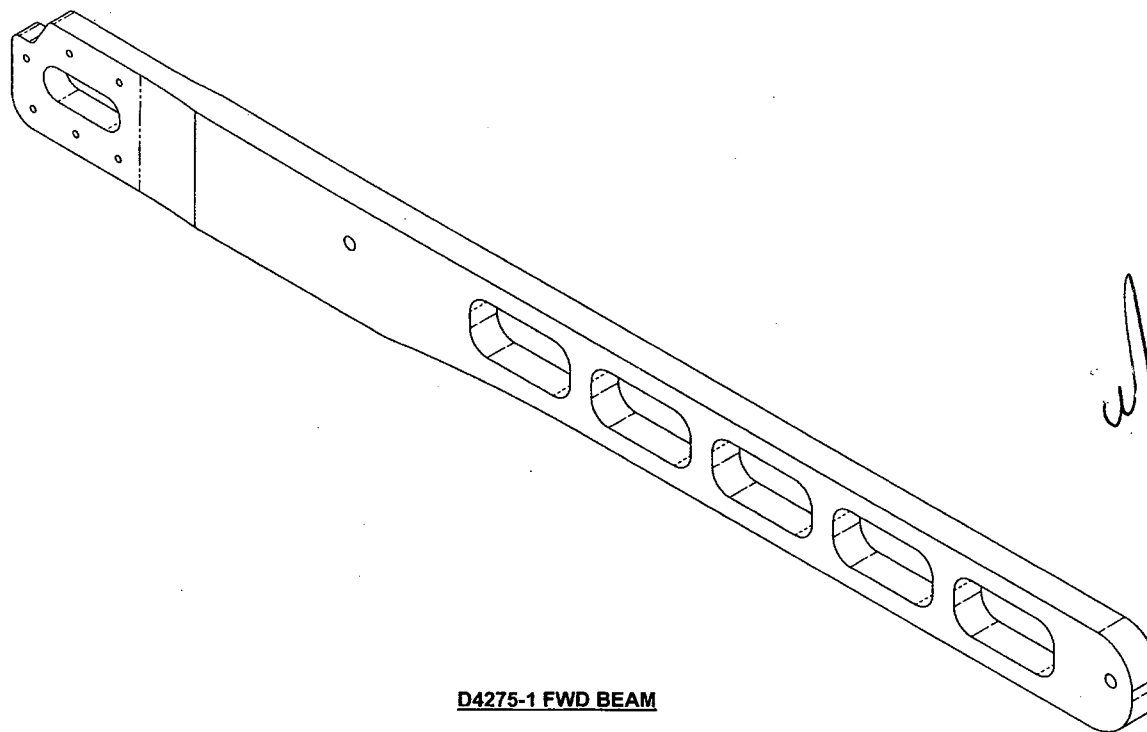
| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries



D4275-1 FWD BEAM

RELEASED
2010-11-30

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 8.29 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT.

| | | | | | |
|------------|----------------|-----------|--|--------------|----------|
| A | | NEW ISSUE | | SC | 10.11.25 |
| REV. | DESCRIPTION | | | BY | DATE |
| DESIGN | SC | | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| DRAWN | JPH | | | | |
| CHECKED | SC | | DRAWING NO. | REV. A | |
| MFG. APPR. | JPH | | D4275 | SHEET 1 OF 2 | |
| APPROVED | SC | | TITLE | SCALE | |
| DE APPR. | JPH | | FWD BEAM | NTS | |
| DATE | 10.11.25 | | COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | | |

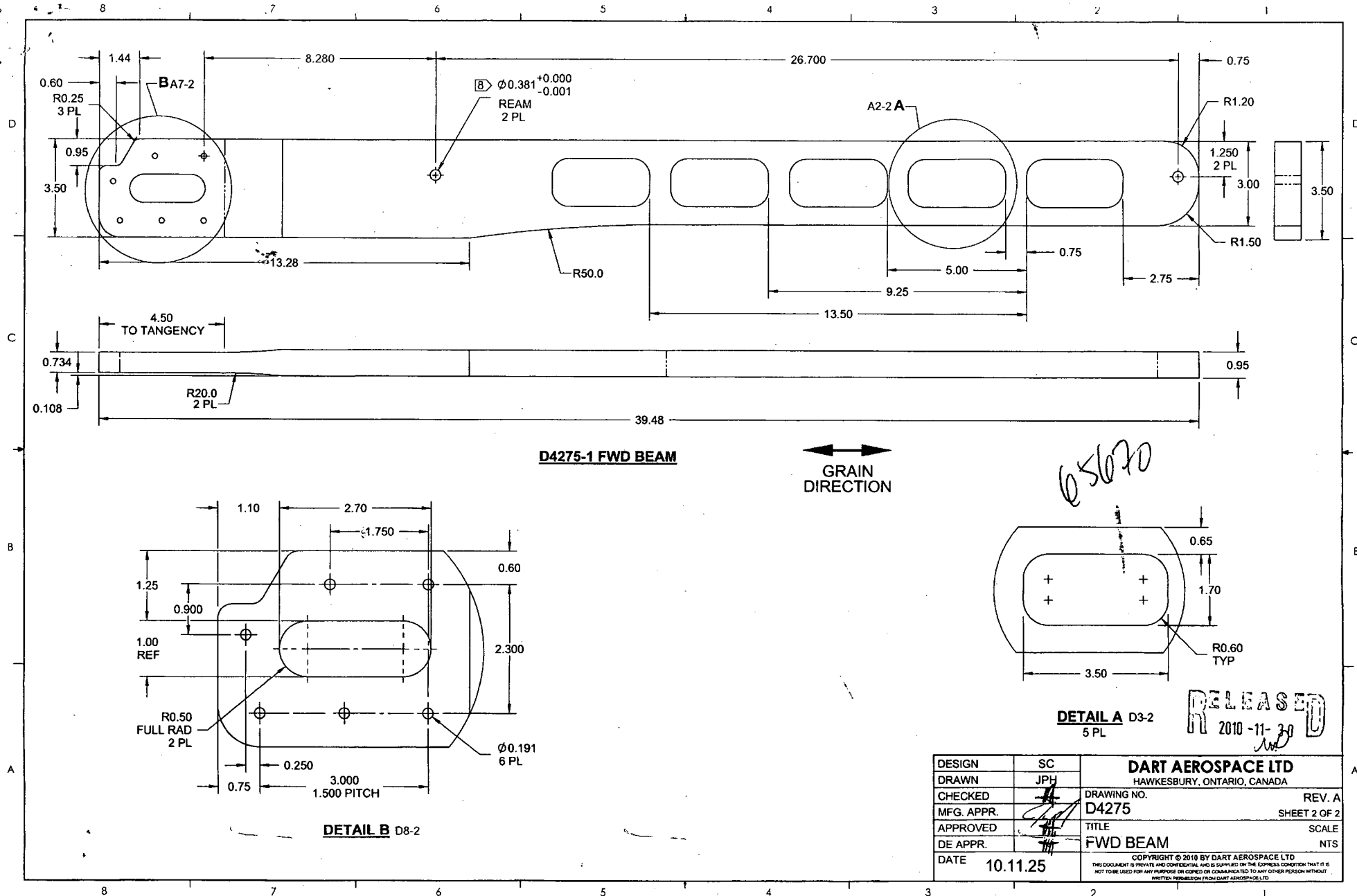
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NOTE: Date & initial all entries



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NOTE: Date & initial all entries

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|--|--|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 65670 |
| Description: FWD BEAM | | Part Number: D4275-1 |
| Inspection Dwg: D4275 , Rev: A | | Page 1 of 2 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------------|------------------|--------|--------|----------------------|----------|
| 3.50 | +/- .030 | 3.503 | ✓ | | Vern | GA-01 |
| 0.95 | +/- .030 | 0.950 | ✓ | | D-6 | GA-08 |
| R 0.25 | +/- .030 | R0.250 | ✓ | | R-6 | ref. |
| 8.280 | +/- .010 | 8.280 | ✓ | | Vern | CNC-02 |
| Ø 0.381 | +0.000 / -0.001 | Ø 0.3810 | ✓ | | Mic | GA-03 |
| 26.700 | +/- .010 | 26.700 | ✓ | | TAPE | GA-12 |
| 0.75 | +/- .030 | 0.752 | ✓ | | Vern | GA-01 |
| 1.250 | +/- .010 | 1.246 | ✓ | | H-6 | 31006 |
| 3.00 | +/- .030 | 3.004 | ✓ | | Vern | GA-01 |
| 3.50 | +/- .030 | 3.505 | ✓ | | " | " |
| 2.75 | +/- .030 | 2.754 | ✓ | | " | " |
| 0.75 | +/- .030 | 0.752 | ✓ | | " | " |
| 5.00 | +/- .030 | 5.002 | ✓ | | " | " |
| 4.50 | +/- .030 | 4.495 | ✓ | | " | " |
| 0.734 | +/- .010 | 0.729 | ✓ | | " | " |
| 0.108 | +/- .010 | 0.104 | ✓ | | Dial | HAAS 2 |
| 39.48 | +/- .030 | 39.480 | ✓ | | TAPE | GA-12 |
| 0.95 | +/- .030 | 0.949 | ✓ | | Vern | GA-01 |
| 1.750 | +/- .010 | 1.750 | ✓ | | " | " |
| 2.70 | +/- .030 | 2.696 | ✓ | | " | " |
| 1.10 | +/- .030 | 1.101 | ✓ | | " | " |
| 1.25 | +/- .030 | 1.253 | ✓ | | " | " |
| 0.900 | +/- .010 | 0.900 | ✓ | | H-6 | 31006 |

| |
|-------------------------|
| Measured by: M.A |
| Date: 11/01/28 |

| |
|-------------------------------|
| Audited by: <i>amz</i> |
| Date: 11/02/01 |

| |
|----------------------------|
| Prototype Approval: |
| Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |